

Work Order ID 77681

77681

Page 1

Friday, December 16, 2011 12:47:04 PM

Item ID: D3389-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web

Start Date: 12/16/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/6/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date: 11-12-11 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr:	Revision Nbr								
D3389	Rev D								
100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2500-3-100								
	2- Deburr								
	3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.								
	4- Cut to finished length								
	5- Open holes to finished size as per dwg D3389								
	6- Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									

④ 12-15

12 01 05 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 1/6/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop ***NR2***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

JW

12-1-6

SAO

12-01-06

JW

12-01-06

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00


150

QC

Memo

0.00

Quality Control

12/1/9 MF
12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, December 16, 2011 12:47:08 PM

Work Order ID: 77681

77681

Parent Item: D3389-1

D3389-1

Parent Item Name: Web

Start Date: 12/16/2011

Required Date: 1/6/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A05.08.31 New issue KJ/JLM
 IPP Rev:B 06-02-08 As per Rev C JLM
 IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

54.0000

1

4

**

D2500-3-100

Ext'n - 'I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

54

51957

2

66298

52

4

GA

12-01-05

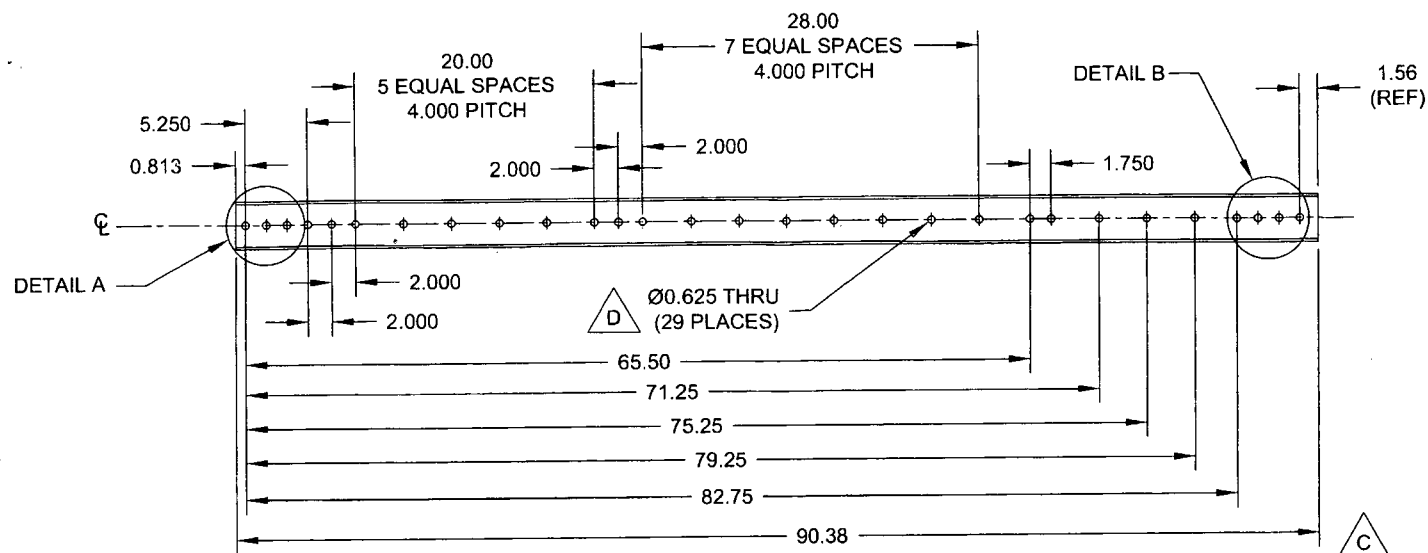
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

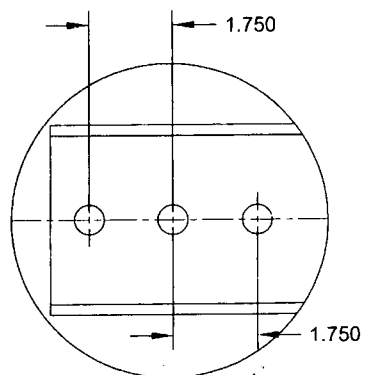
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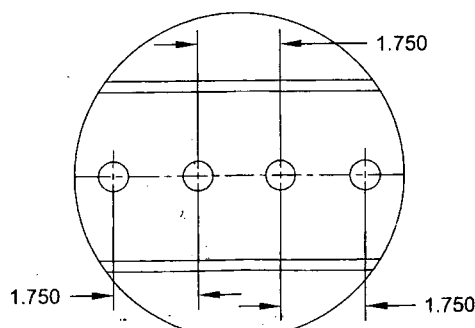
NOTE: Date & initial all entries



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 7-7-681

07-12-14

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. **D3389** REV: **D**
SHEET 1 OF 1

TITLE **412 WEB** SCALE **1:10**

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Dart Aerospace Ltd

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